

Date: Tuesday, 15/07/2008 4:12:00 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SADDLE FITTING, FWD (OUTBOARD/INBOARD)	
<b>Job Number</b> :	40515	<b>Part Number</b> :	D2572	
<b>Estimate Number</b> :	10531	<b>Drawing Number</b> :	D2572 REV E	
<b>P.O. Number</b> :		<b>Project Number</b> :	N/A	
<b>This Issue</b> :	15/07/2008	<b>Drawing Revision</b> :	E	
<b>Prsht Rev.</b> :	NC	<b>Material</b> :		
<b>First Issue</b> :	1/1	<b>Due Date</b> :	08/08/2008	<b>Qty:</b> 10 <b>Um:</b> Each
<b>Previous Run</b> :	40085	<b>Type</b> :	MACHINED PARTS	
<b>Written By</b> :				
<b>Checked &amp; Approved By</b> :	<u>JW 08.7.16</u>			
<b>Comment</b> :	Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ			

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6101005	Saddle Billet
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
 7075-T7351 8.25X5.0X2.5  
 Make from D6101-005 billet for D2572  
 Ensure that grain is along 5.00" length  
 Batch No: B34874

JW 08/08/13

16

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Program Batch No. 90515 Double check by: Y.A

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets  
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets  
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets  
 4-Deburr and remove all machining marks  
 5-Tumble to remove shap edges.

JW / J.F. 08/08/15 (10)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE  
 Machine keyway as per dwg D2571 & D2572

J.F. 08/08/15 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 4:12:00 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 40515

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/08/15 (10)

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

S.S. 08/08/19 (10)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MJ 08/08/19 (10)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:45  
320°F  
12:15

M.F. 08/08/19

(10X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

SR 08-08-19 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 432

JS 08/08/20 (X10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/21

Job Completion



mf 08-08-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 40515	
<b>Description:</b> Saddle, Fwd Inboard		<b>Part Number:</b> D2572	
<b>Inspection Dwg:</b> D2572 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.441	.440	.439			
B	1.745	1.755		1.750	1.750	1.749"	1.750"		
C	3.495	3.505		3.499	3.506	3.501"	3.501"		
D	1.745	1.755		1.750	1.750	1.749"	1.750"		
E	7.990	8.010		8.006	8.006	8.005"	8.005"		
F	0.490	0.510		.499	.500	.504"	.504"		
G	0.257	0.262		.259	.259	.260	.260		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.499	.500	.500	.500		
J	1.174	1.184		1.179	1.178	1.178	1.178		
K	0.558	0.578		.565	.570	.569	.568		
L	1.174	1.184		1.179	1.178	1.178	1.178		
M	1.490	1.500		1.492	1.494	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.499	2.506		
O	3.869	3.879		3.871	3.871	3.874	3.874		
P	0.115	0.135		.126	.126	.126	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.249	.249	.250	.251		
S	0.115	0.135		.135	.134	.134	.134		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.966	2.960	2.960		
V	0.230	0.250		.236	.237	.239	.239		
W	0.115	0.135		.133	.132	.131"	.132"		
X	0.307	0.312		.307	.307	.307"	.307"		
Y	0.760	0.765		.761	.766	.760"	.760"		
Z	0.352	0.372		.367	.366	.366"	.368"		
AA	0.470	0.530		.500	.500	.500	R.500"		
AB	0.615	0.635		.626	.636	.630"	.630"		
AC	0.053	0.073		.063	.063	.063"	.063"		
AD	0.240	0.260		.241	.241	.243	.242		
AE	1.375	1.395		1.390	1.391	1.388	1.388		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.248	.246	.249	.250		
AI	2.000	2.020		2.005	2.006	2.005	2.005		
AJ	0.023	0.043		.032	.033	.033"	.033		
Accept/Reject									

Measured by: <i>mf</i>
Date: 08/08/13

Audited by: <i>88</i>
Date: 08/08/19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>mf</i>

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 40515
<b>Description:</b> Saddle, Fwd Inboard		<b>Part Number:</b> D2572
<b>Inspection Dwg:</b> D2572 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.438	0.443		0.439	0.439	0.439	0.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.501	3.501	3.501	3.501		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.025	8.025	8.025	8.025		
F	0.490	0.510		0.501	0.505	0.501	0.507		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.376	0.377	0.377	0.377		
I	0.490	0.510		0.502	0.502	0.502	0.503		
J	1.174	1.184		1.182	1.182	1.182	1.182		
K	0.558	0.578		0.570	0.566	0.568	0.569		
L	1.174	1.184		1.180	1.180	1.181	1.181		
M	1.490	1.500		1.499	1.499	1.496	1.496		
N	2.495	2.505		2.502	2.502	2.502	2.502		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.126	0.126	0.126	0.125		
Q	0.115	0.135		0.127	0.127	0.127	0.127		
R	0.240	0.260		0.252	0.251	0.251	0.250		
S	0.115	0.135		0.135	0.132	0.130	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.959	2.959	2.959	2.959		
V	0.230	0.250		0.243	0.244	0.244	0.244		
W	0.115	0.135		0.133	0.135	0.133	0.135		
X	0.307	0.312		0.307	0.309	0.310	0.309		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.372	0.372	0.372	0.372		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.631	0.630	0.630	0.630		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.240	0.252	0.250	0.252		
AE	1.375	1.395		1.386	1.386	1.387	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.280	0.280	0.280	0.280		
AH	0.240	0.260		0.249	0.253	0.251	0.253		
AI	2.000	2.020		2.005	2.005	2.005	2.005		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: J.F.
Date: 08/08/15

Audited by: [Signature]
Date: 08/08/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	[Signature]

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 40515
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b> D2572
<b>Inspection Dwg:</b> D2572 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

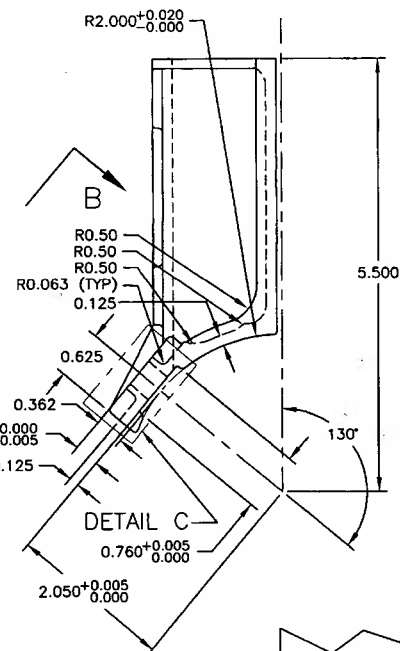
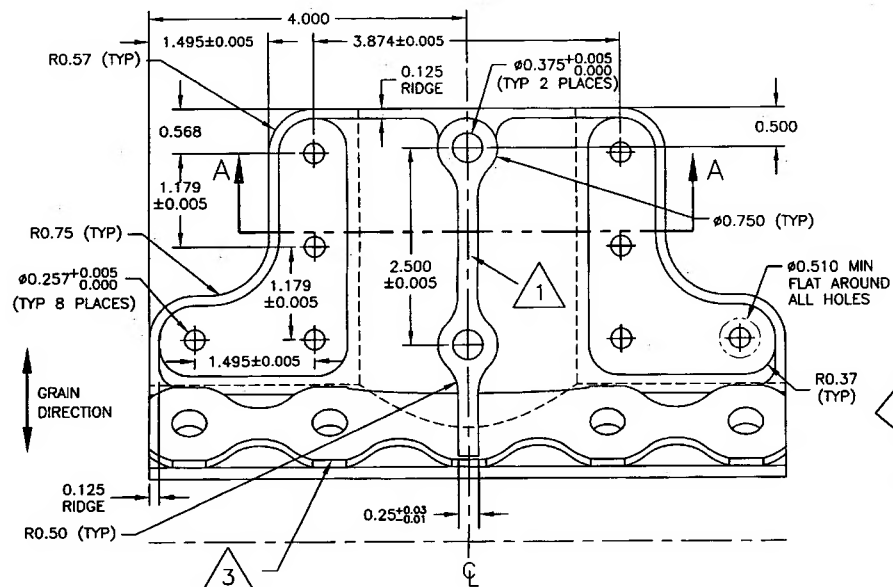
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	19	210	3	4		
A	0.438	0.443		0.438"	0.439"	<del>0.438"</del>			
B	1.745	1.755		1.750"	1.750"				
C	3.495	3.505		3.501"	3.501"				
D	1.745	1.755		1.750"	1.750"				
E	7.990	8.010		8.005"	8.005"				
F	0.490	0.510		0.505"	0.505"				
G	0.257	0.262		0.258"	0.258"				
H	0.375	0.380		0.377"	0.377"				
I	0.490	0.510		0.503"	0.503"				
J	1.174	1.184		1.182"	1.182"				
K	0.558	0.578		0.570"	0.570"				
L	1.174	1.184		1.181"	1.181"				
M	1.490	1.500		1.496"	1.496"				
N	2.495	2.505		2.502"	2.502"				
O	3.869	3.879		3.874"	3.874"				
P	0.115	0.135		0.126"	0.126"				
Q	0.115	0.135		0.127"	0.127"				
R	0.240	0.260		0.250"	0.250"				
S	0.115	0.135		0.135"	0.135"				
T	0.178	0.198		0.188"	0.188"				
U	2.940	2.980		2.959"	2.959"				
V	0.230	0.250		0.244"	0.244"				
W	0.115	0.135		0.135"	0.135"				
X	0.307	0.312		0.310"	0.310"				
Y	0.760	0.765		0.760"	0.760"				
Z	0.352	0.372		0.372"	0.372"				
AA	0.470	0.530		0.500"	0.500"				
AB	0.615	0.635		0.630"	0.630"				
AC	0.053	0.073		0.063"	0.063"				
AD	0.240	0.260		0.255"	0.255"				
AE	1.375	1.395		1.387"	1.387"				
AF	0.115	0.135		0.135"	0.135"				
AG	0.240	0.280		0.280"	0.280"				
AH	0.240	0.260		0.253"	0.253"				
AI	2.000	2.020		2.025"	2.025"				
AJ	0.023	0.043		0.023"	0.023"				
Accept/Reject									

Measured by:	J.F.
Date:	08/08/15

Audited by:	RF
Date:	08/08/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

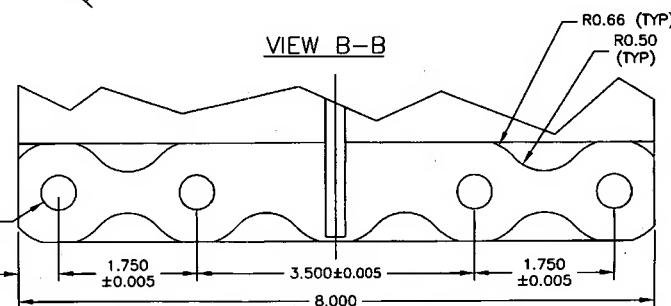
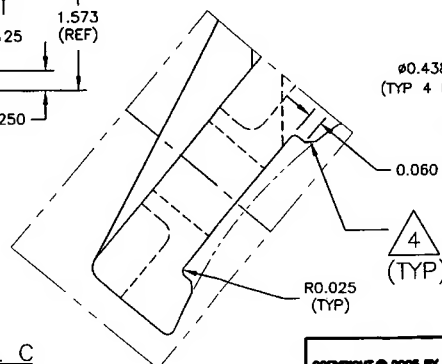
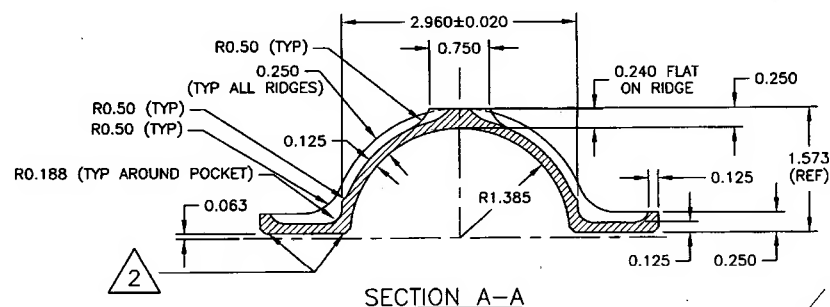
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


## NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACEF ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4		
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES		
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177		
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425		
A	96.09.16	NEW ISSUE		
DESIGN DS		DRAWN BY PH		DART AEROSPACE LTD. HARVEESBURY, ONTARIO, CANADA
CHECKED 	APPROVED 	DRAWING NO. D2572	REV.	SHEET 1 OF
DATE 05.07.13		TITLE INNER FWD SADDLE	SCALE	2

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DART AEROSPACE LTD.

**DART** **DART AEROSPACE LTD.**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.	REV
D2572	SHEET 1 OF 1
TITLE	SCALE
INNER FWD SADDLE	

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 40515

DETAIL C  
SCALE 2:1